

Work Order ID 61077

Thursday, August 05, 2010 11:35:20 AM



Page 1

Item ID: D3912-041

Accept



Setup

Start



Revision ID:

Item Name: Eyebolt Receiver Assembly

Stop



Start Date: 8/5/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 8/12/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: MFDate: 10-8-05 Tooling:

Date:

Run

Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3912 B

100



Packaging

Packaging

110



Small Fab

Small Fab

Memo

0.00

Memo

0.00

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/08/10

42

E8c0/08/10 (2)E8c0/08/10

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 61077

Thursday, August 05, 2010 11:35:20 AM



Page 2

Item ID: D3912-041

Accept

Revision ID:

Item Name: Eyebolt Receiver Assembly

Start Date: 8/5/2010 Start Qty: 2.00



Required Date: 8/12/2010 Req'd Qty: 2.00



Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____

Date:

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop

Sequence ID/
Work Center ID

Packaging

Packaging

Operation
DescriptionIdentify as per dwg & Stock Location: 507Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/8/10 MF10/8/10 MF

10-8-10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, August 05, 2010 11:35:19 AM

Page 1

Work Order ID: 61077



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

Start Date: 8/5/2010

Required Date: 8/12/2010

Comments:

IPP RevA: new issue DD 09.11.18 verified by:EC
 IPP Rev:B
 10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
 WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
 D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
 FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
 VERIFIED:DD

Start Qty: 2.00

Required Qty: 2.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|----------------|--------------|---------------|-------------------|---------------------|
| D3912-1 | | Manufactured | No | | | 100 | Each | 6.0000 | 1 | 2 | | <i>B61081 (2)</i> | <i>8/5/10/08/09</i> |
| Eyebolt | | | | | | | <u>Location</u> | | <u>Loc Qty</u> | | | | |
| | | | | | | | FG096 | | 6 | | | | |
| | | | | | | | | | 6 | | | | |
| D3912-3 | | Manufactured | No | | | 59441 | | | 100 | Each | 10.0000 | 2 | <i>8/5/10/08/09</i> |
| Eyebolt Block | | | | | | | <u>Location</u> | | <u>Loc Qty</u> | | | | |
| | | | | | | | ST096 | | 10 | | | | |
| | | | | | | | | | 10 | | | | |
| D3912-5 | | Manufactured | No | | | 59430 | | | 100 | Each | 1.0000 | 2 | <i>8/5/10/08/09</i> |
| Eyebolt Plate | | | | | | | <u>Location</u> | | <u>Loc Qty</u> | | | | |
| | | | | | | | ST096 | | 1 | | | | |
| | | | | | | | | | 1 | | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Thursday, August 05, 2010 11:35:20 AM

Page 2

Work Order ID: 61077



Parent Item: D3912-041



Parent Item Name: Eyebolt Receiver Assembly

D3801-1



Hand Retractable Spring Plunger

Manufactured

No

Each

18.0000

Start Date: 8/5/2010

Start Qty: 2.00

Required Date: 8/12/2010

Required Qty: 2.00



1
2
J30/08/09

MS20615-4M20



RIVET

Purchased

No

Loc Qty

Loc Code

Location

ST088

18

40736

2

56905

16

Each

282.0000



2
16
J30/08/09

MS21209-F615



Heli-Coil

Purchased

No

Loc Qty

Loc Code

Location

ST323

282

114808

112

115054

170

Each

99.0000



16
J30/08/09

NAS1149F032P 6632

10.08.10

Purchased

No

Loc Qty

Loc Code

Location

ST305

99

108170

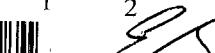
78

108244

21

Each

619.0000



2
J30/08/09

WASHER

PTC

Location

ST275

Loc Qty

Loc Code

18057

619

619

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|---|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10.08.10 | | PERMANENT CHG. T1PO ON B.O.M. CHANGE NAS1149033P TO NAS11490663R. M19185 (20) AN06C616 | EP | 10/08/10 | 2 | 10.08.10 ast d42 | S 10/08/10 |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

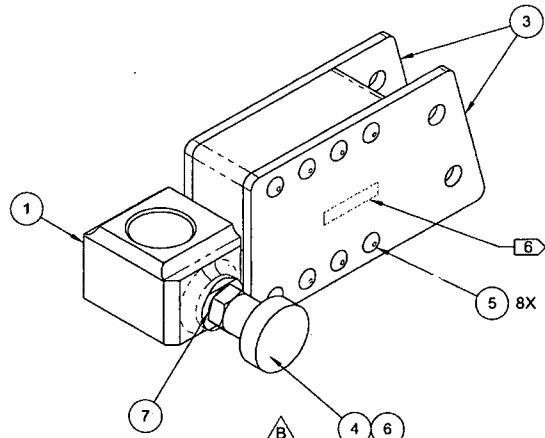
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

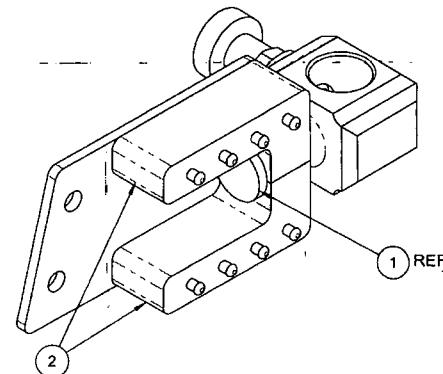
NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|---------------|-----------------------|
| | X | D3912-041 | EYEBOLT RECEIVER ASSY |
| 1 | 1 | D3912-1 | EYEBOLT |
| 2 | 2 | D3912-3 | EYEBOLT BLOCK |
| 3 | 2 | D3912-5 | EYEBOLT PLATE |
| 4 | 1 | D3801-1 | SPRING PLUNGER |
| 5 | 8 | MS20615-4M20 | RIVET |
| 6 | 1 | MS21209-F615 | HELICAL |
| 7 | 1 | NAS1149C0663R | WASHER |

0663R 10.08.10



D3912-041 EYEBOLT RECEIVER ASSY



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

RELEASED
2010-07-16
14

| | | | | |
|------------|---|--------------------------------|------|----------|
| B | D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER; NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. | | JPH | 10.06.28 |
| A | NEW ISSUE | | JPH | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE | |
| DESIGN | 115 | DART AEROSPACE LTD | | |
| DRAWN | 115 | HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED | | REV. B | | |
| MFG. APPR. | | DRAWING NO. D3912 | | |
| APPROVED | | SHEET 1 OF 3 | | |
| DE APPR. | | TITLE EYEBOLT RECEIVER ASSY | | |
| DATE | 10.06.28 | SCALE NTS | | |

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

D

D1

C

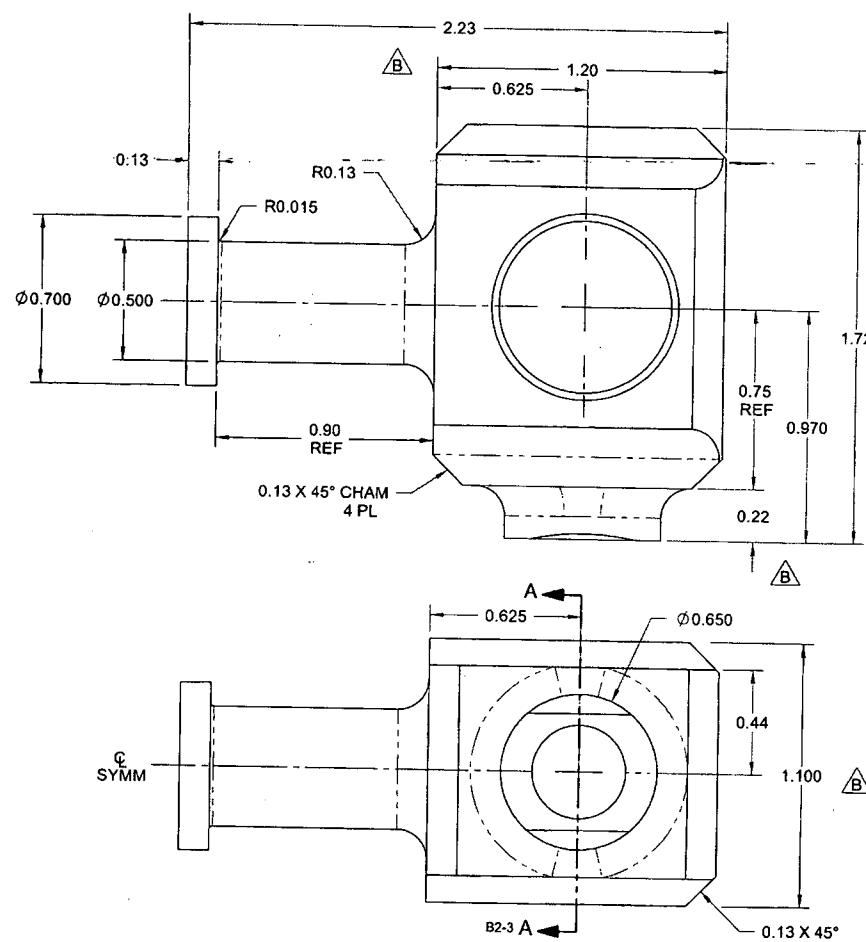
C

B

B

A

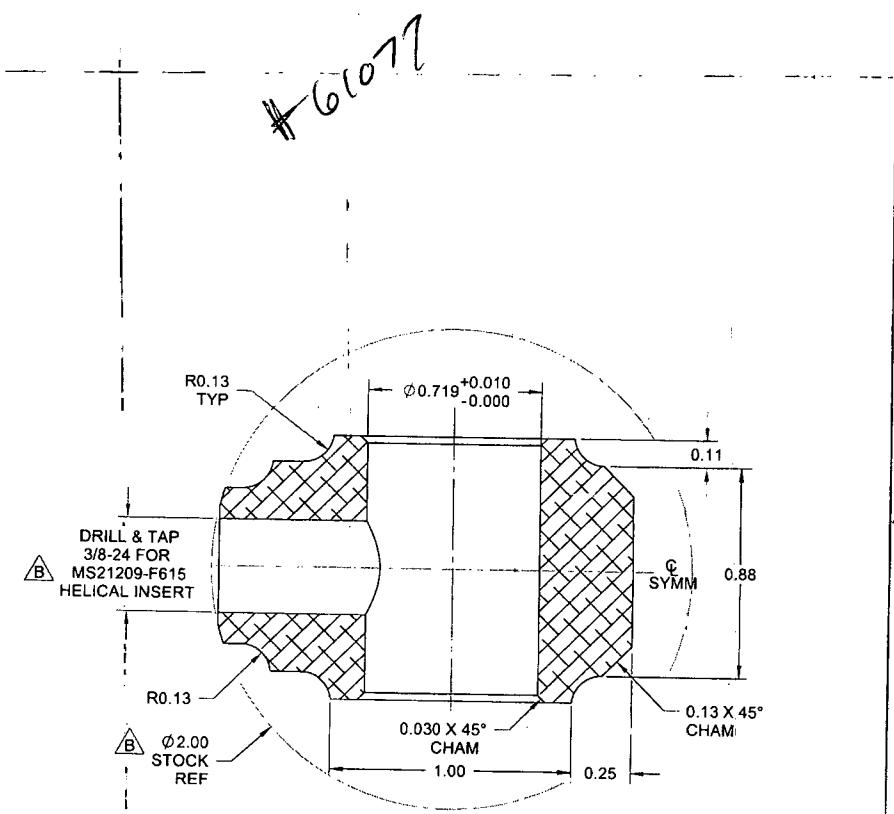
A



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16
[Handwritten signature]

| | | |
|------------|------------|-----------------------------|
| DESIGN | <i>A/S</i> | DART AEROSPACE LTD |
| DRAWN | <i>MM</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | |
| MFG. APPR. | <i>MM</i> | REV. B |
| APPROVED | <i>MM</i> | SHEET 2 OF 3 |
| DE APPR. | <i>MM</i> | TITLE |
| DATE | 10.06.28 | SCALE |

EYEBOLT RECEIVER ASSY NTS

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD

8

7

6

5

4

3

2

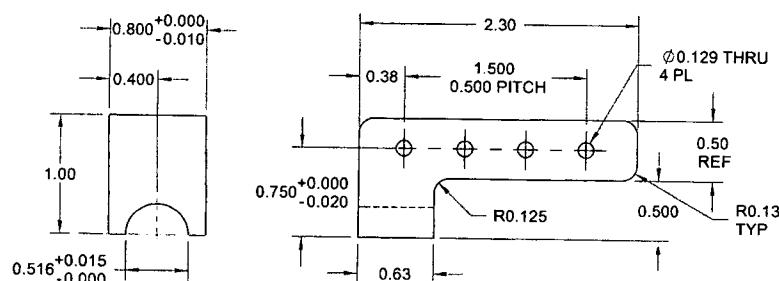
1

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

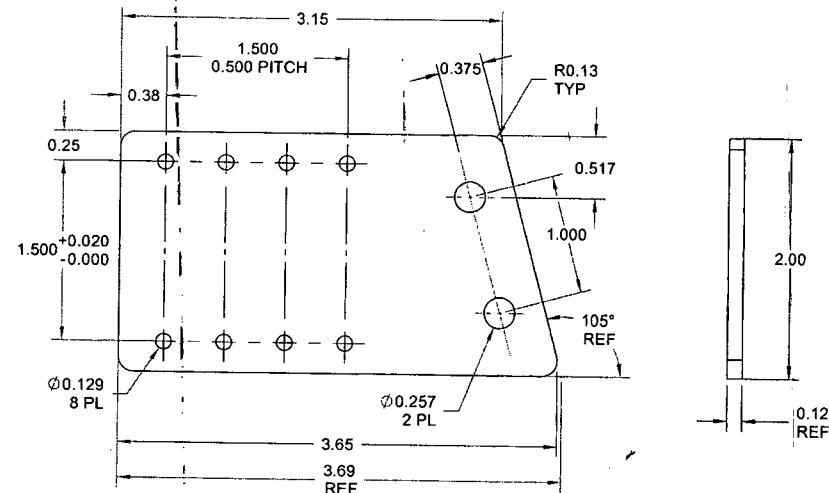
NOTE: Date & initial all entries



D3912-3 EYEBOLT BLOCK

NOTES:

- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M303S11GA OR M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs



D3912-5 EYEBOLT PLATE

RELEASED
2010-07-16
JMP

| | | |
|------------|------------|-----------------------------|
| DESIGN | <i>1/S</i> | DART AEROSPACE LTD |
| DRAWN | <i>1/S</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>1/S</i> | |
| MFG. APPR. | <i>1/S</i> | REV. B |
| APPROVED | <i>1/S</i> | SHEET 3 OF 3 |
| DE APPR. | <i>1/S</i> | TITLE |
| DATE | 10.06.28 | SCALE |
| | | NTS |

EYEBOLT RECEIVER ASSY

COPYRIGHT © 2010 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries